

Date: Friday, 11/04/2008 10:25:35 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 38567
Estimate Number : 10371
P.O. Number :
This Issue : 11/04/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : SMALL /MED FAB
Previous Run : 38549
Written By :
Checked & Approved By :
Comment : Est:B 03.05.09 Reformat KJ/RF
 Est Rev:C 08-04-11 now made on water jet DD verified by:EC

Drawing Name : LUG
Part Number : D30177
Drawing Number : D3017 REV. A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 15/04/2008 **Qty:** 20 **Um:** Each

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 M4130NS049 4130 Sheet .049 wall



Comment: Qty.: 0.1071 sf(s)/Unit Total : 2.1420 sf(s)

Material: AISI 4130N Sheet, 0.049" thick

(M4130N-S049) Batch: 11612 18 8-4-14

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3017

Dwg Rev: A

Prog Rev: A

18 8-4-14

29

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

18 8-4-14

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8 08/04/14 counts 29

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr

18 08/04/14

29

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 38567

Part Number: D30177

Job Number:



Seq. #:

Machine Or Operation:

Description :

To Fit DTB598 08-04-14
2-Form-as-per-Dwg D3017

SPB 08/04/15 (29)

6.0

QC5

INSPECT WORK TO CURRENT STEP



08-04-15 (X24)



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Pat D,



Comment: PACKAGING RESOURCE #1

Identify and bag with light oil (Vactra oil #2), then Stock

Location: WS

AS 08-04-16 29

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/16 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



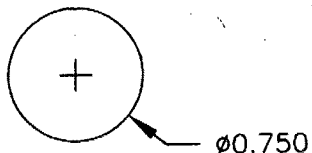
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

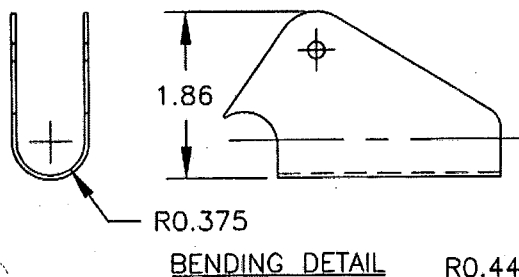
NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

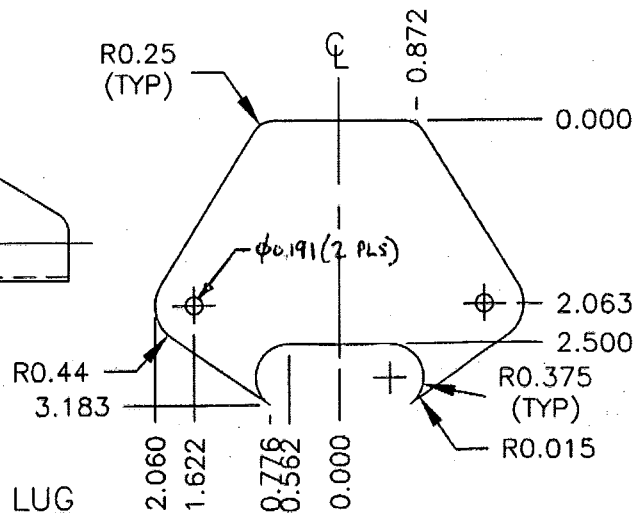
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WORK ORDER
NO. 38549



D3017-11 END CAP
SCALE 1:1



BENDING DETAIL



D3017-7 LUG
SCALE 2:1

FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

RELEASED
01.05.30

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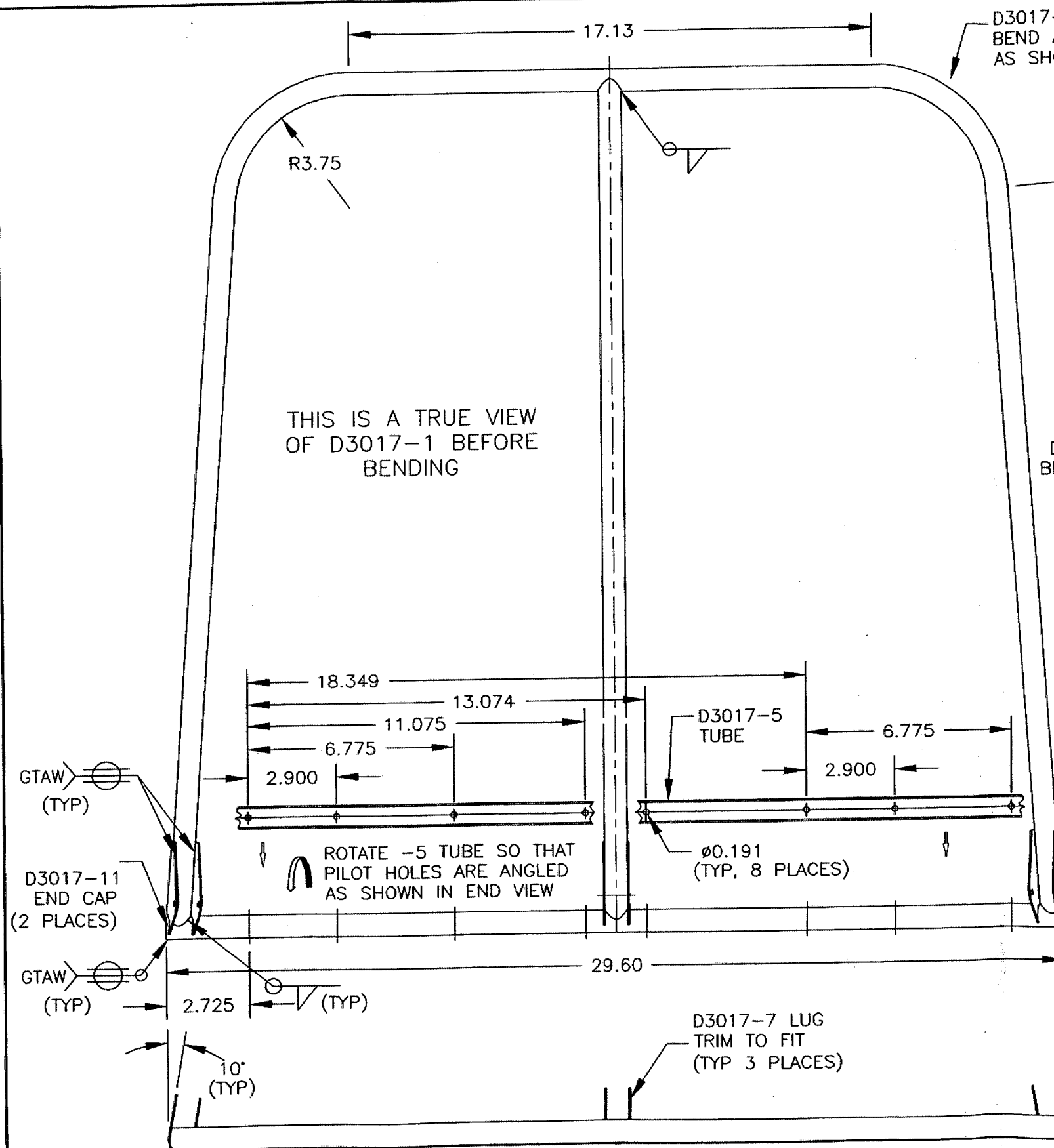
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3017-1 TUBE,
BEND AND CUT
AS SHOWN

DRILL $\phi 0.128$ HOLES TO LINE UP
WITH D3023-1 BACK PANEL

17.92
DIST BETWEEN
BEND TANGENTS

22.05

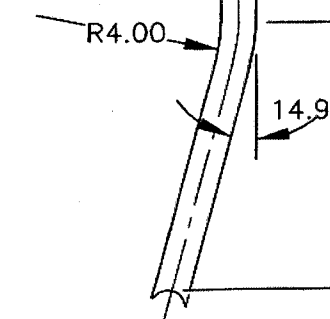
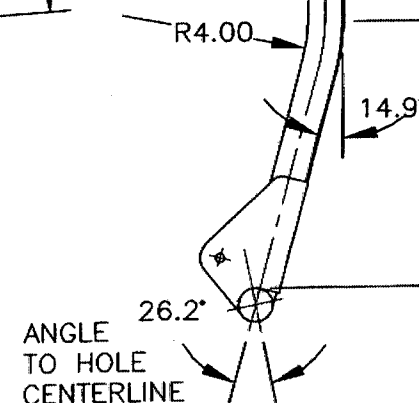
27.89

R0.38
(TYP)

21.30

27.14

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WORK ORDER
NO. 38549



D3017-3 TUBE

RELEASED
01-06-07

D3017-041 BACK FRAME ASSEMBLY
(D3017-1 TUBE, D3017-5 TUBE)

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	CHECKED H	APPROVED H		
	DATE 01.05.18	TITLE BACK FRAME ASSEMBLY		